

Work Order ID 160662

Tuesday, May 02, 2017 3:09:40 PM

160662

Page 1

Item ID: D3552-15

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Prop

Start Date: 5/3/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/10/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
13
5-89

Date: MAY 03 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3552	L								

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O:

Purchase Part Number: B8-154-387-300NX

Supplier: LS Technologies

Certificate of conformity is required

2

MAY 04 2017

DAS
13
5-89

110

0.00

110

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.04

Packaging

Ensure certificate of conformity is attached

2x SPIT-5-9

120

0.00

120

QC

QC6- All purchased or subcontracted products

Memo

0.00

Quality Control

Test for correct pressure

2

DAS
38
5-89MAY 01 2017
MAY 10 2017

Work Order ID 160662

Tuesday, May 02, 2017 3:09:40 PM

160662

Page 2

Item ID: D3552-15

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Prop

Start Date: 5/3/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/10/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 57363

0.00

130

Packaging

Memo

0.02

Packaging

2 MAY 10 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

DAS
21
9-00

MAY 10 2017

17/5/11 DJ

Picklist Print

Tuesday, May 02, 2017 3:09:40 PM

Page 1

Work Order ID: 160662

160662

Parent Item: D3552-15

D3552-15

Parent Item Name: Door Prop

Start Date: 5/3/2017

Required Date: 5/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.24 new issue DD Verf:EC
10.12.03 as per dwg rev.G DD verf:EC
PER ECN12-624 DD verf:EC

IPP Rev:B
IPP Rev:C 12.07.30 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B8-154-387-300NX		Purchased	No			110	Each	0.0000	1	2			

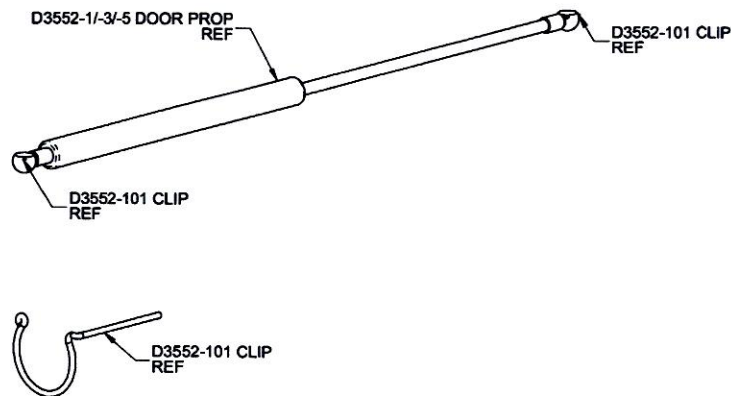
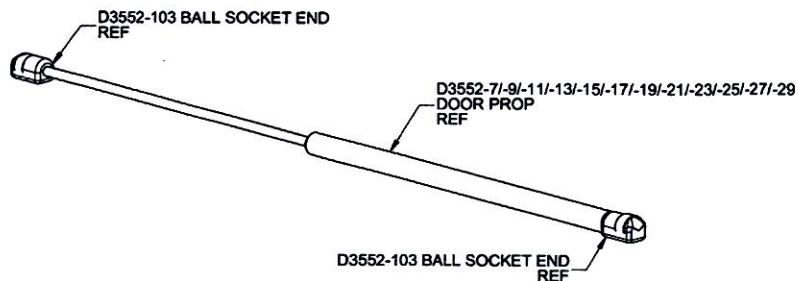
B8-154-387-300NX

Gas Spring

**

2x SP17-5-9.

SPECIFICATION CONTROL DRAWING



MAY 03 2017
DAS
13
S-89

W/O: 160662

RELEASED
2015-08-04
ECN 15-609

REV.	DESCRIPTION	BY	DATE
L	ADD P/N D3552-29	VS	15.04.13
K	ADD "X" TO LS TECHNOLOGIES P/Ns TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-25/-27. REASON: PART 2-209.	MB	12.07.16
J	ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 138/6.06 NOW 154/6.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 386/15.2 NOW 387/15.2.	AP	11.12.07
I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE: 300/87.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 138/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	AK	DRAWING NO.	REV. L
MFG. APPR.	DD	D3552	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR PROP	NTS
DATE	15.04.13	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-220-530-140N
D3552-15	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300NX
D3552-17	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	158/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-158NX
D3552-19	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060NX
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-070N
D3552-25	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300NX
D3552-27	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	158/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-158NX
D3552-29	DOOR PROP	190/7.48	475/18.7	100/22.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-100N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

D3552-X DOOR PROP

RELEASED
2015-08-04

- NOTES:
 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23/-25/-27/-29 DOOR PROPS

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	DRAWN	VS			
	CHECKED	AK	DRAWING NO.	REV. L	
	MFG. APPR.	DD	D3552	SHEET 2 OF 2	
	APPROVED	HS	TITLE	SCALE	
	DE APPR.	DS	DOOR PROP	NTS	
DATE		15.04.13		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36188**

Purchase Order Date 5/4/2017

PO Print Date 5/4/2017

Page Number 1 of 2

Order From :
LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

1-2017
MAY 10 2017

Contact Name
Vendor Phone 306 683 5000
Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	B8-154-387-300NX AS PER DWG D3552-15 REV. L B160662	Gas Spring DAS 38 9-89	5/10/2017 Yes 5/10/2017		2.00 Each	\$26.50	\$53.00
Line Total:							\$53.00
2	B8-154-387-156NX AS PER DWG D3552-17 REV. L B160661	Gas Spring	5/10/2017 Yes 5/10/2017		4.00 Each	\$26.50	\$106.00
Line Total:							\$106.00
3	B6-167-410-070N AS PER DWG D3552-21 REV. L B160660	Gas Spring	5/10/2017 Yes 5/10/2017		2.00 Each	\$26.50	\$53.00

PO Instructions: Fedex Acc#151793240

Note:

5/4/2017

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
36188	5/05/2017	16549

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
5/05/2017	Fed-Ex	

Qty	Description
2	D3552-15 B160662 Gas Spring (B8-154-387-300NX)
4	D3552-17 B160661 Gas Spring (B8-154-387-156NX)
2	D3552-21 B160660 Gas Spring (B6-167-410-070N)
Shipping Via FED EX Tracking # 779076793313	

897-59

Order checked by: 

DAS
38
9-89



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

May 05, 2017

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

✓ 2 Units : D3552-15 B160662 Gas Spring (B8-154-387-300NX) Carbon Steel Gas Spring

4 Units: D3552-17 B160661 Gas Spring (B8-154-387-156NX) Carbon Steel Gas Spring

2 Units: D3552-21 B160660 Gas Spring (B6-167-410-070N) Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : May 2017

This product is ROHS compliant.

Purchase Order # 36188

Invoice # 16549

L S Technologies Inc Canada

A blue ink signature of Nolan Fehr, written over a horizontal line.

Nolan Fehr
Manager